

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002737**Date Inspected:** 29-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	Wu Ming Kai , Zhao Chen Sun ,Huang Wen-Pang			CWI Presenting:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG / Tower**Summary of Items Observed:****Bay 3**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in bay 3 it was noted that ZPMC was in process for fit-up at multiple stages on side and bottom plates. . ZPMC Certified Welding Inspector Wu Ming Kai was present at the time of observation and this QA inspector spoke with Mr. Kai on the work in process for bay 3. It was stated that tack welds for WT and strait stiffener plates were in process and at the gantry SP428-001 was being welded with fillet weld under WPS-B-T-2132-3 which ZPMC's CWI Zhao Bao was monitoring the welding parameters and welding progression at this station.

Bay 4

During the continued observation by this QA inspector it was noted in bay 4 that ZPMC was welding on diaphragm plate splice for component number SSD1-SA261- 1 a/b & 2 a/b, ZPMC CWI Zhao Chen Sun was present within this bay monitoring welding progression and parameters for the Submerged Arc Welding (SAW) process. It was noted that the CWI was monitoring pre-heat and interpass temperatures per the approved WPS. Welding continued throughout this QA inspectors shift.

Bay 7

This QA inspector observed ZPMC in bay 7 performing in process welding and back gouging of web plates for floor beam components. It was noted that ZPMC's CWI Huang Wen-Pang was present during the welding operations in this bay and monitoring welding parameters and in progress progression. During the observations it was noted that ZPMC was extending the weld grooves for the Complete Joint Penetration (CJP) weldments that intersected at approximately 30° angle. It was discussed with the CWI pertaining to this area to affirm this was an acceptable and approved process. ZPMC informed this QA inspector that it was approved and had the

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documentation with the Caltrans stamped drawings showing this detail on sheet FB110 of the floor beam fabrication procedure.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
